

Work Order ID 86229

86229

Page 1

June-25-12 10:30:43 AM

Item ID: D3535-13

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 25/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/25

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3535

Rev B

(B)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

304 .040

B12-G-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-G-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/2/06/27

(B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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June-25-12 10:30:43 AM

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Revision ID:

Item Name: Wearshoe

Stop ***NS2***

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8

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00				13			SK 12/07/12
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				13			
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:40 OVEN TEMPERATURE: 320°F FINISH TIME: 8:10					13X			MX 12/07/14

m121279

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Stop *NS2*

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Cust Item ID:

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8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-25-12 10:30:46 AM

Page 1

Work Order ID: 86229

86229

Parent Item: D3535-13

D3535-13

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	352.7693	0.8505	7.162105	13	11.5	
M304S20GA									**				
304/316 .040 Sheet												1812-6-X	

Location

Loc Qty

Loc Code

001

52.4914105

121192

52.4914105

MAT020

300.277922

117933

27.3442

118400

5.3723

118964

23.2

119346

24.8

121380

49.761422

121901

169.8

121901

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DART AEROSPACE LTD		Work Order:	86229
Description: Wearshoe		Part Number:	D3535-13
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	1		V B02	
2.000	+/-0.010	2.000	2		V	
5.650	+/-0.010	5.650	h		T	
9.150	+/-0.010	9.150	1		T B01	
14.066	+/-0.010	14.066	h		T	
18.983	+/-0.010	18.983	h		T	
23.900	+/-0.010	23.900	h		T	
27.400	+/-0.010	27.400	7		T	
29.400	+/-0.010	29.400	h		T	
32.900	+/-0.010	32.900	h		T	
Ø0.188	+0.005/-0.001	.190	2		V	
20.00	+/-0.030	20.00	h		T	
14.00	+/-0.030	14.00	h		T	
8.00	+/-0.030	8.00	h		T	
5.00	+/-0.030	5.00	h		T	
0.300	+/-0.010	.304	h		V	
0.300	+/-0.010	.301	h		V	
0.038	+/-0.010	.036	h		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-6-22	Date: 12/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

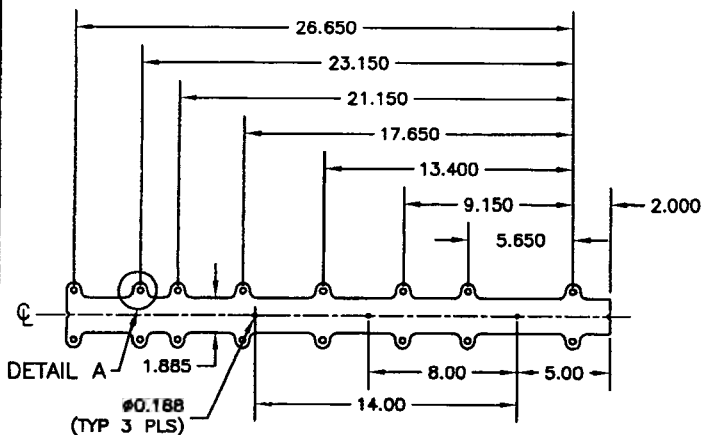
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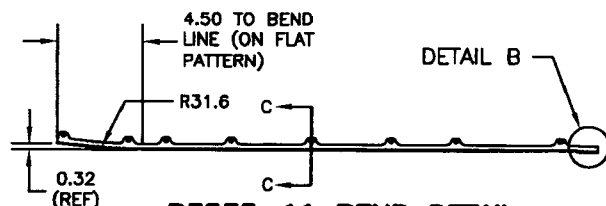


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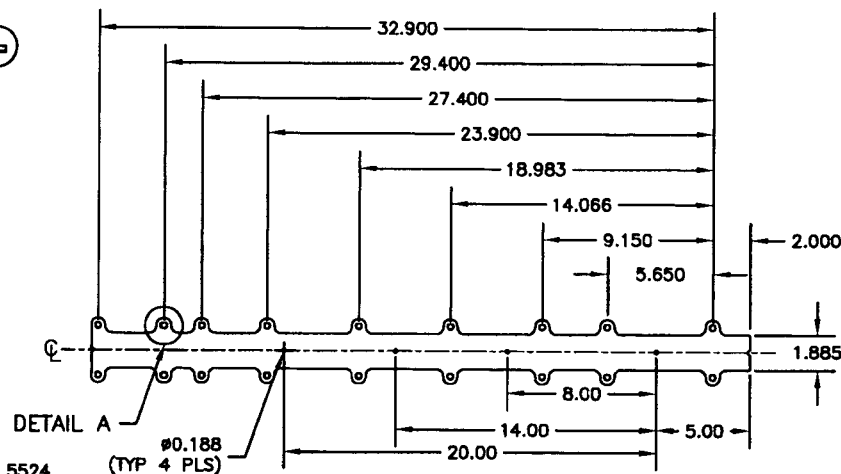
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 06229 H L J
12/06/25



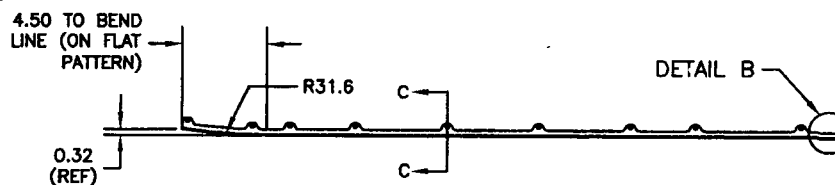
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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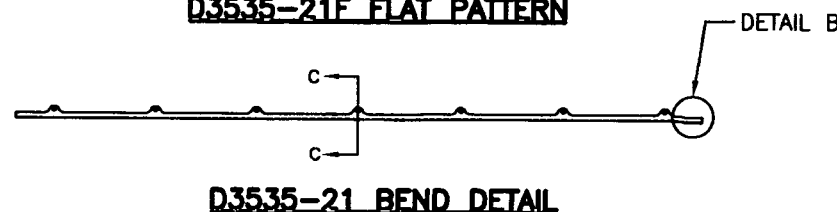
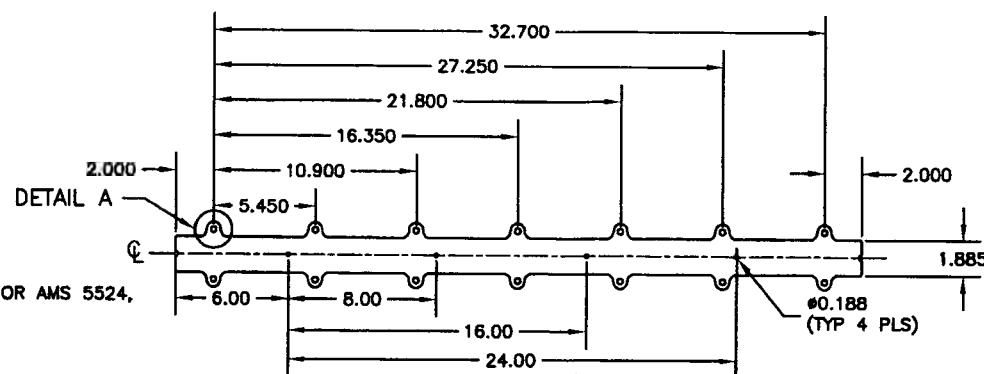
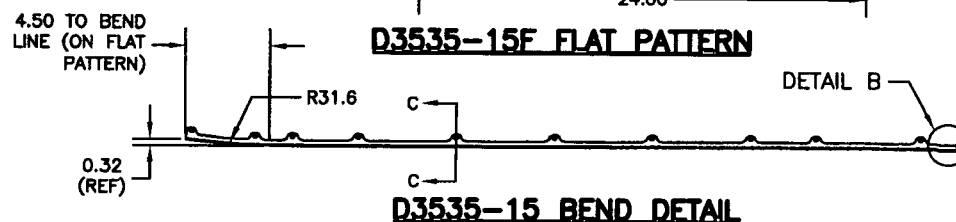
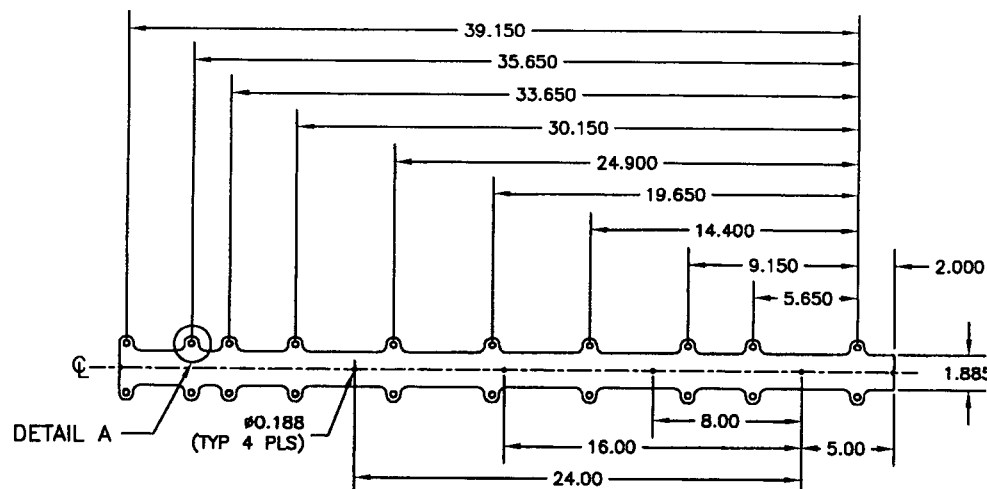
NOTE: Date & initial all entries

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07.04.24

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 2 OF 7
	SCALE 1:10	



NOTES

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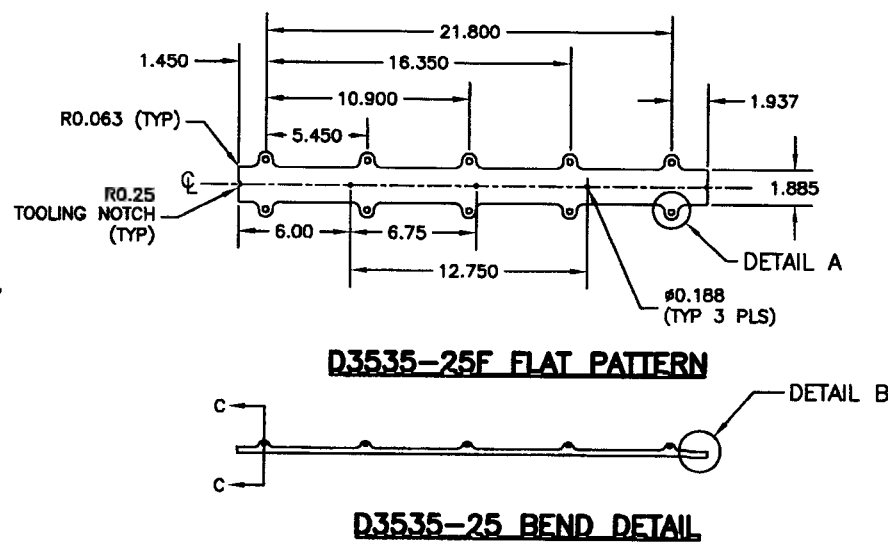
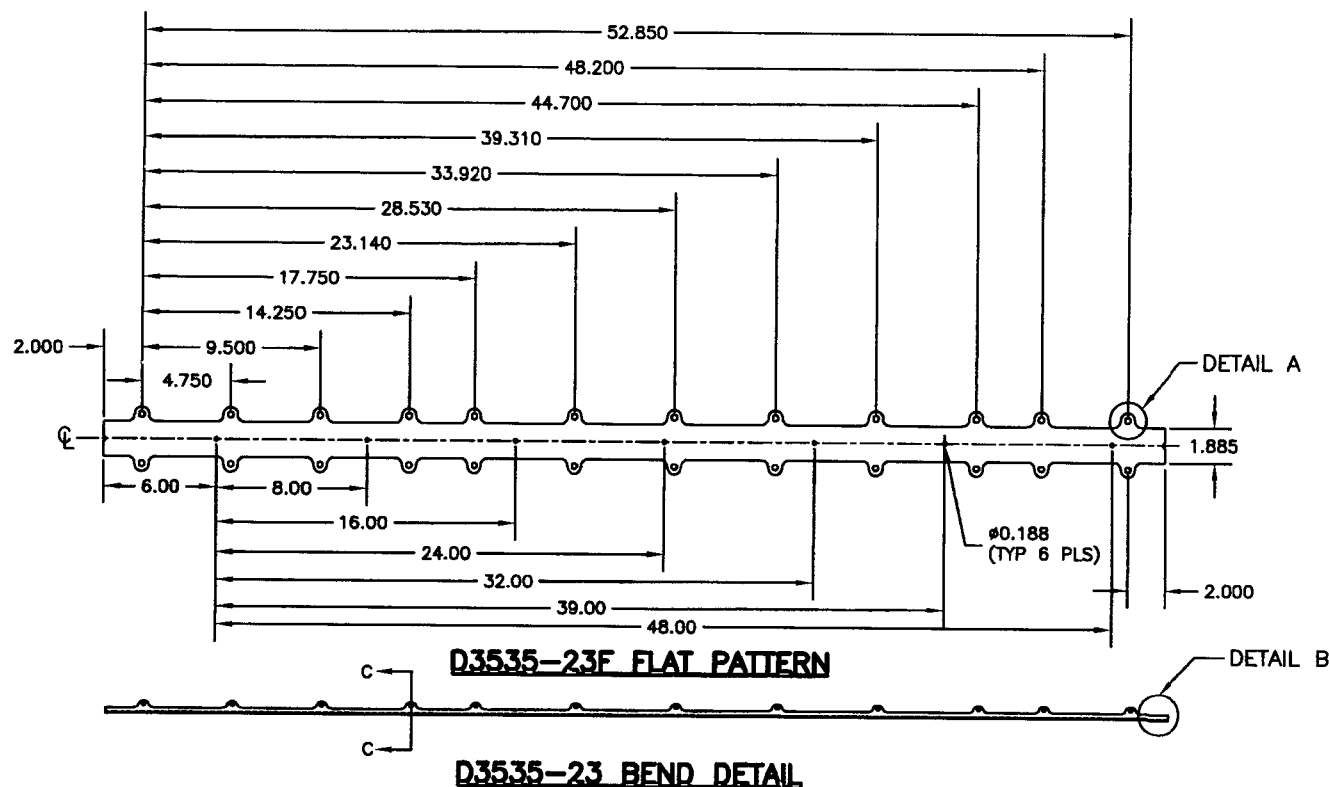
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07.04.24

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DESIGN	C B	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REVISION
		WEARSHOE		SHEET 3 OF 7
				SCALE
				1:10

W/O:		WORK ORDER CHANGES					
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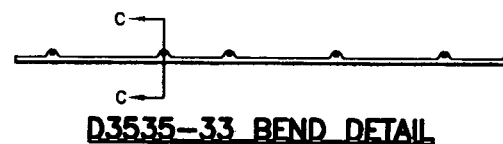
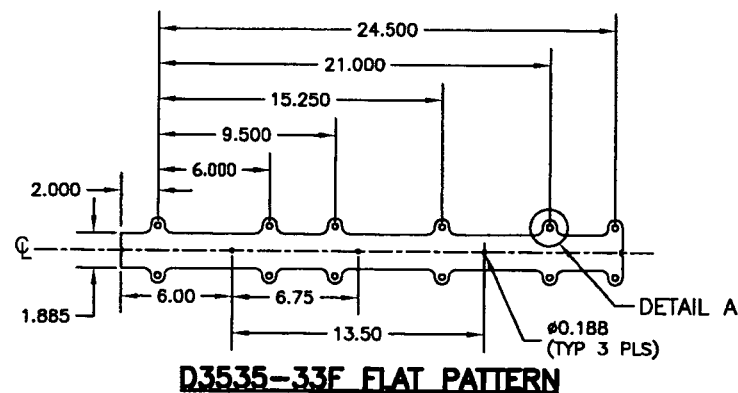
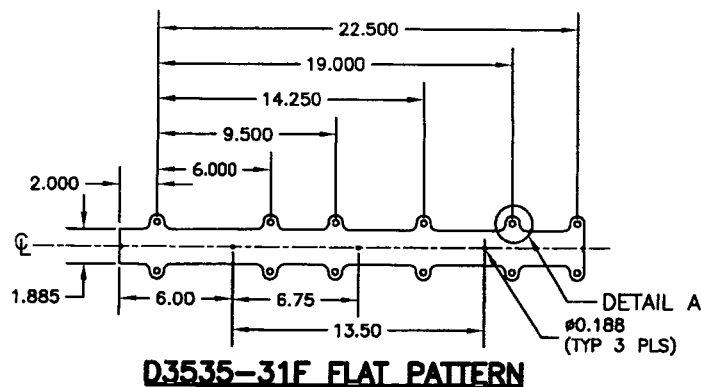
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07.04.24



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

W/O:		WORK ORDER CHANGES					
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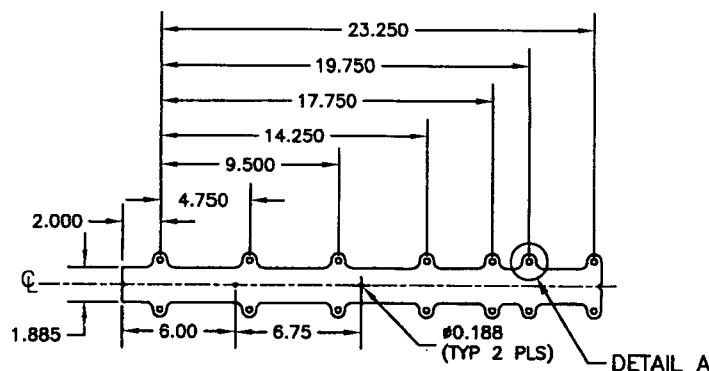
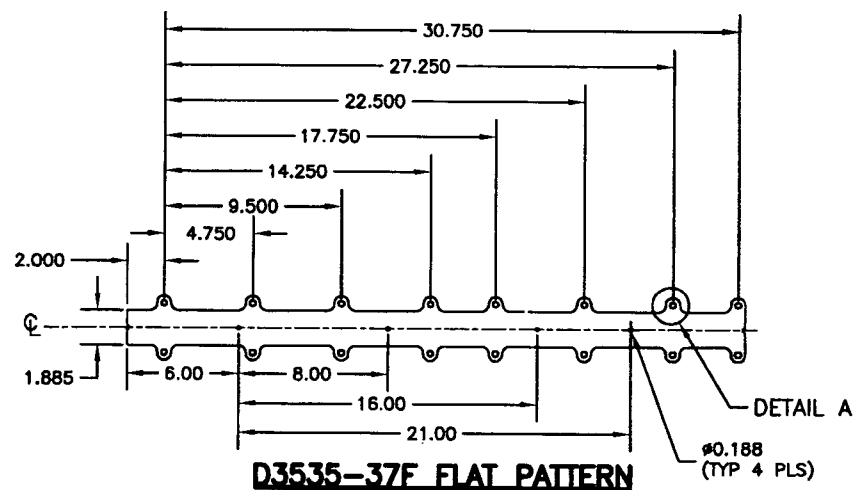
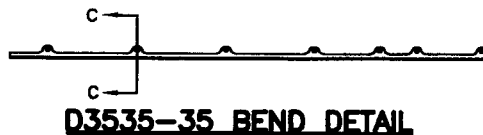
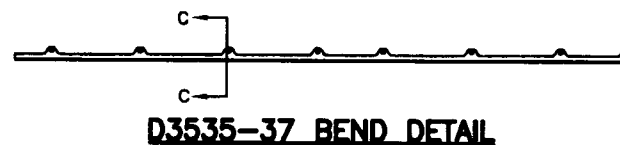
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26229

DARTRELEASED
07.04.17**D3535-35F FLAT PATTERN****D3535-37F FLAT PATTERN****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 5 OF 7	SCALE 1:10

W/O:		WORK ORDER CHANGES					
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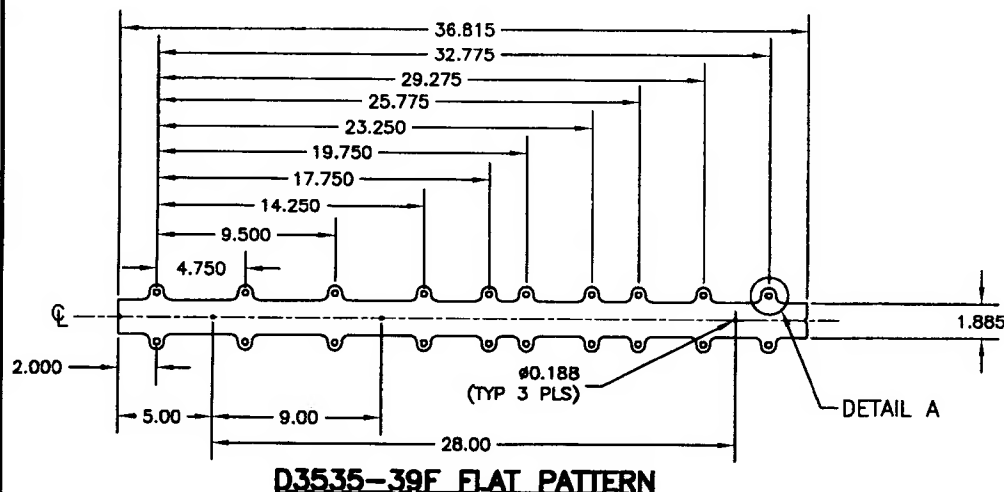
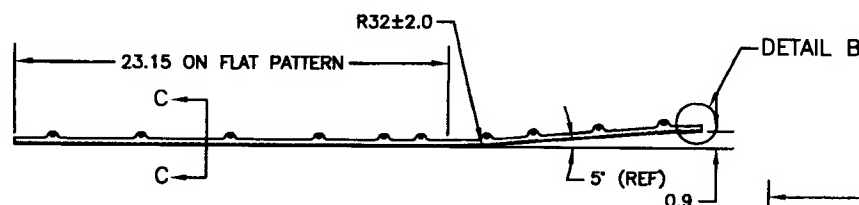
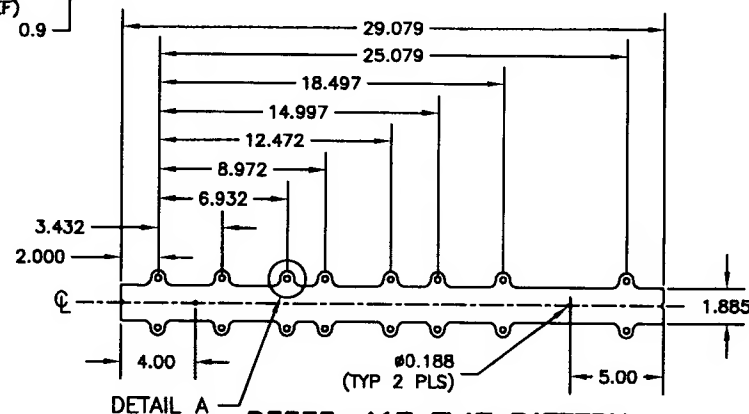
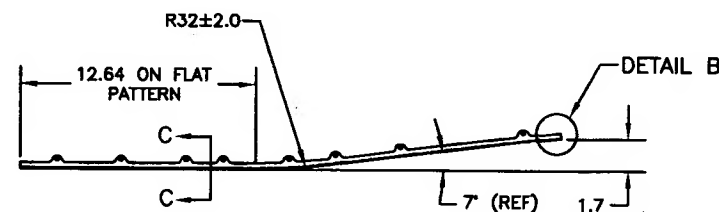
NOTE: Date & initial all entries

86229



RELEASED

07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 6 OF 7
				SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

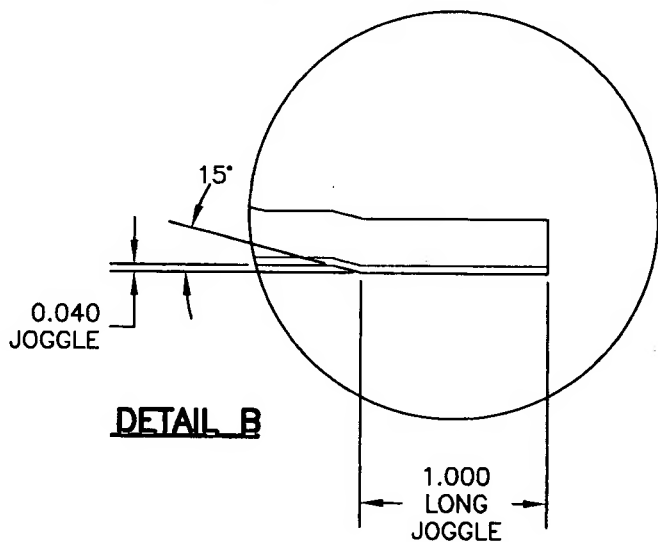
NOTE: Date & initial all entries



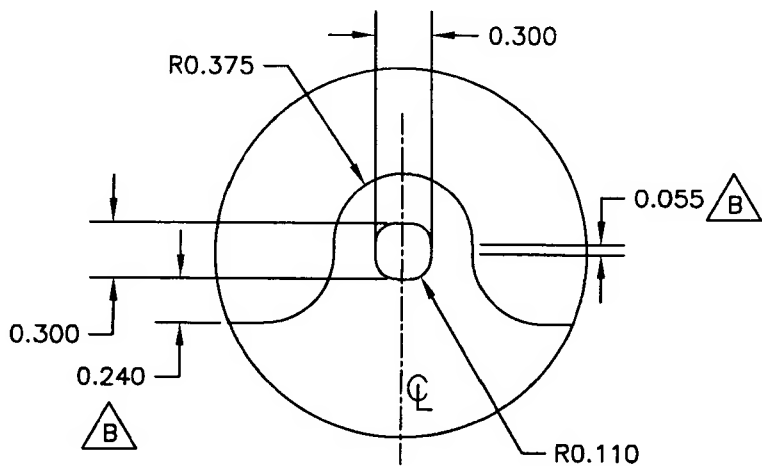
962,29

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
				SCALE 1:1

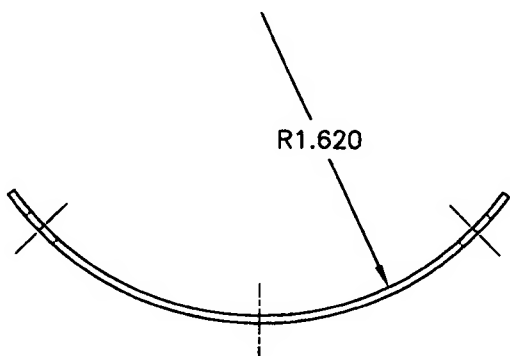
RELEASED
07.04.24



DETAIL B



DETAIL A



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries